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D4634-145
Job Sheet 167078-H



Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	5d
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-5 <i>SC23277</i>	1 <i>SC22933</i>	3	0	0
	D4636-5 <i>SC23376</i>	1	43	0	0
	D4647-1 <i>SC23373</i>	1	4	0	0
	D4664-5 <i>SC23371</i>	6	39	0	0
	D4712-1 <i>SC23369</i>	1	4	0	0
	D4732-17 <i>SC23362</i>	1	0	0	0
	D4732-23 <i>SC23365</i>	1	1	0	0
	D4732-27 <i>SC23361</i>	1	1	0	0
	D5021-5 <i>SC22760</i>	1	1	0	0
	MPNY-750S-9-C <i>SC23358</i>	9	570	0	0
	MS20426AD3-4 <i>SC23357</i>	4	5,055	0	0
	MS20426AD4-6 <i>SC23355</i>	2	2,797	0	0
	MS21059L08 <i>SC22355</i>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐	Skid-tube ☐ Machining ☐	Cross tube ☐ Small Fab ☐	Water Jet ☐ Prod. Eng. Coord. ☐	Engineering ☐ Quality ☐ Other ☐																																				
Date: _____ Step #: _____		 S022956																																							
Description Work Order Deviation: _____		 Aft, Center Ceiling Replacement Panel Assembly																																							
		PART NO: D4634 – 145 Revision: Operation: Start up Operation Change No:																																							
		Mfg Date: 12/15/17 Job No: 167078 – H																																							
Root Cause <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Environment ☐</td> <td style="width: 33%;">No Re-verification ☐</td> <td style="width: 33%;">Pressure/ ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td>OTHER: ☐</td> </tr> </table>		Environment ☐	No Re-verification ☐	Pressure/ ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐	OTHER: ☐	Completed By: _____ Ind / Supervisor: _____ Val Verification: _____ QA Coordinator: _____ Approval: _____ tioned Wrong: _____ side Dimensions: _____ Over/Under tolerance: _____ Part Incorrect: _____ Part Lost/Missing: _____ Part Moved: _____ Drawing: _____ Finish: _____ Misread: _____ Turning Sequence: _____			
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